

Work Order ID 75667

75667

Page 1

October-27-11 3:42:09 PM

Item ID: D135-751-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Installation

Start Date: 27/10/2011 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

5/12/03/29

JLW MLS 12-3-27

B75667

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 27/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

12-02-24

DP 12-3-12

W/O:		WORK ORDER CHANGES					
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Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____


Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

7/5/12-3-12
CF

12-3-13

PTC

W/O: 75667		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-3-13	160	Should read QC7		12-3-13 2014.02			

Part No: D135-751-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop ***NS2***

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Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

170

Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M120813Exp Date: 12-8-13start time: 9:35end time: 12/03/14 10:30

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: M120164

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

12-3-13HG/CF 12-3-1312/03/148E 12/03/14CF 12-3-14

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 07/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC10- Inspect visual per QSI004- ground welds	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Rivet D3506-1/-3 as per Dwg D3507.								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

8/2/13/14

1 ~~0~~ CF 12-3-15

5/2/13/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Start Date: 27/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Pressure Wash per QSI005 4.3	0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:50 OVEN TEMPERATURE: 320 FINISH TIME: 4:30								
230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.00							
Quality Control									

IX p m / 12/03/17

1 BL 12-3-19

IX p m / 12/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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October-27-11 3:42:09 PM

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Installation

Start Date: 27/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

0.00

260

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M1190000
Exp Date: 12/08

3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Screws where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: M1190000
Exp Date: 12/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M110348

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 1190004

IX 10/11/12/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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75667

October-27-11 3:42:09 PM

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

270

0.00

QC

Memo

Quality Control

Pick Kit

0.00

280

0.00

Packaging

Memo

Packaging

QC4- 100% Inspect kits for completeness

0.00

290

0,00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 75667

75667

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Item ID: D135-751-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube Installation
 Start Date: 27/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: <u>8</u>								
	PPP Rev: <u>B</u>								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

1x SP12-03-29

12/4/2

12-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 75667

75667

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No				Each	461.0000		38			
AI S7-1032-130													
Insert													
				<u>Location</u>				<u>Loc Qty</u>					
				ST281				461					
				117717				27					
				118386				146					
				118966				288					
D3507-1-BENT		Manufactured	No			120	Each	0.0000	1	1			
D3507-1-BENT													
Skidtube Assembly EC135													
D3504-1		Manufactured	No			170	Each	7.0000	2	2			
D3504-1													
Crossbolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>					
				LG				5					
				71130				5					
				LG001				2					
				53742				2					

120/81

**

38 m/12/03/23
 *

77442

**

① 2

D 12-3-12

BE 12-03-14
 B 75240 *p

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No

170 Each 14.0000 1 1

D3504-3

Crossbolt Spacer

**

BE 12/03/14

Location

Loc Qty

Loc Code

LG001

14

53743

14

D3504-5 Manufactured No

170 Each 5.0000 2 2

D3504-5

Crossbolt Spacer

**

BE 12/03/14
B 76239

Location

Loc Qty

Loc Code

LG

5

71226

5

D3505-1 Manufactured No

170 Each 3.0000 1 1

D3505-1

Web

**

①
H/G 12-3-13
/ ac 12/03/13

Location

Loc Qty

Loc Code

LG

3

75211

3

D3506-1 Manufactured No

190 Each 0.0000 4 4

D3506-1

Doubler

**

74733

4 CF 12-3-15

D3506-3 Manufactured No

190 Each 63.0000 2 2

D3506-3

Doubler

**

② CF 12-3-15

Location

Loc Qty

Loc Code

ST063

63

51790

63

W/O:		WORK ORDER CHANGES					
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D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W3

Purchased

No

190

Each

2,404.000

12

12

MS20601-AD4W3

Rivet

**

12

CF 12-3-15

Location

Loc Qty

Loc Code

ST321

2404

114538

2404

ALS4-1032-225

Purchased

No

260

Each

2,438.000

1

1

ALS4-1032-225

Insert

**

120671

1 m-12/03/23

Location

Loc Qty

Loc Code

ST281

2438

108696

586

110768

62

118386

860

118966

930

AN3C4A

Purchased

No

260

Each

2,469.000

31

31

AN3C4A

BOLT

**

120769

31 m-12/03/23

Location

Loc Qty

Loc Code

ST350

2469

117313

2

117688

5

117872

22

118112

16

118451

2

118706

444

118838

978

119328

1000

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

260

Each

1,176.000

2

2

AN3C5A

Bolt

120423

**

2 m-l 12/03/23

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1169

116419

28

117343

17

117764

169

117872

2

118451

453

119127

500

AN526C1032R10

Purchased

No

260

Each

261.0000

2

2

AN526C1032R10

Screw

**

m-l 12/03/23

Location

Loc Qty

Loc Code

FP-B

87

108062

87

ST327

100

114494

100

ST328

74

110049

74

AN960C10L

NAS1149C0332
R

Purchased

No

260

Each

0.0000

33

33

***AN960C10L ***

washer

120648

**

33 m-l 12/03/23

October-27-11 3:42:14 PM

Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 75667

75667

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2965 Manufactured No

260 Each 39.0000 1 1

D2965

Cap, 105 Skidtube

**

m-k 12/03/23

Location

Loc Qty

Loc Code

FP006

39

71371 ✓

39

D2965-3 Manufactured No

260 Each 2.0000 1 1

D2965-3

Cap

**

m-k 12/03/23

Location

Loc Qty

Loc Code

FP005

2

50560 ✓

1

71300 ✓

1

D3492-1 Manufactured No

260 Each 94.0000 4 4

D3492-1

Plug

**

4 m-k 12/03/23

Location

Loc Qty

Loc Code

FP

94

69531

8

73402

6

74444

80

D3492-3 Manufactured No

260 Each 137.0000 4 4

D3492-3

Plug

**

4 m-k 12/03/23

Location

Loc Qty

Loc Code

FP

77

74447

77

ST

60

74871

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 75667

75667

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-7 Manufactured No

260 Each 10.0000 2 2

D3492-7

Plug

Location Loc Qty Loc Code

FA-A 10
71881 10

**

2 m-l 12/03/23

D3508-1 Manufactured No

260 Each 13.0000 1 1

D3508-1

Wearplate

Location Loc Qty Loc Code

FP016 13
61020 1
72933 12

**

m-l 12/03/23

D3508-3 Manufactured No

260 Each 4.0000 1 1

D3508-3

Wearplate

Location Loc Qty Loc Code

FP021 1
38527 1
FP21 3
72169 3

**

m-l 12/03/23

D3508-5 Manufactured No

260 Each 19.0000 1 1

D3508-5

Wearplate

Location Loc Qty Loc Code

FP021 19
71688 7
72416 12

**

m-l 12/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 75667

75667

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-7 Manufactured No

260 Each

6.0000

1 1

D3508-7

Wearplate

**

Location

Loc Qty

Loc Code

FP020

6

72932 ✓

6

D3558-1 Manufactured No

260 Each

13.0000

1 1

D3558-1

Gasket

**

Location

Loc Qty

Loc Code

FP014

13

50925 ✓

1

73561 ✓

12

D3558-3 Manufactured No

260 Each

2.0000

1 1

D3558-3

Gasket

**

Location

Loc Qty

Loc Code

FP014

2

71651

1

72170

1

D3558-5 Manufactured No

260 Each

3.0000

1 1

D3558-5

Gasket

**

Location

Loc Qty

Loc Code

FP014

3

67485

3

75179
75255

m-l 12/03/23

m-l 12/03/23

m-l 12/03/23

m-l 12/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 75667

75667

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-7 Manufactured No

260 Each 3.0000 1 1

D3558-7

Gasket

Location Loc Qty Loc Code

FP014 3

67162 3

NAS1611-007 Purchased No

260 Each 272.0000 2 2

NAS1611-007

O-RING

Location Loc Qty Loc Code

FP-A 272

103697 ✓ 272

NAS1611-010 Purchased No

260 Each 41.0000 4 4

NAS1611-010

O-RING

Location Loc Qty Loc Code

FP 17

117460 8

118077 1

118612 8

FP-A 24

110915 14

119307 10

**

**

**

1 m 12/03/23

m 12/03/23

2

4 m 12/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75667

75667

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

260

Each

152.0000

4

4

NAS1611-013

O-RING

120910

**

W m-k 12/03/23

Location

Loc Qty

Loc Code

FP

55

117291

2

117887

53

FP-A

97

116582

5

119307

92

AN3C4A

Purchased

No

280

Each

2,469.000


8

8

AN3C4A

BOLT

**

m 120187 SP. 

Location

Loc Qty

Loc Code

ST350

2469

117313

2

117688

5

117872

22

118112

16

118451

2

118706

444

118838

978

119328

1000

AN960C10L

NAS1149C0332

Purchased

No

280

Each

0.0000


8

8

***AN960C10I ***

washer

**

m 118354 
SP 12-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 75667

75667

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 27/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3512-1

Manufactured No

280

Each

8.0000

2

2

D3512-1

Wearplate

SP 74735

Location

Loc Qty

Loc Code

ST500

8

73955

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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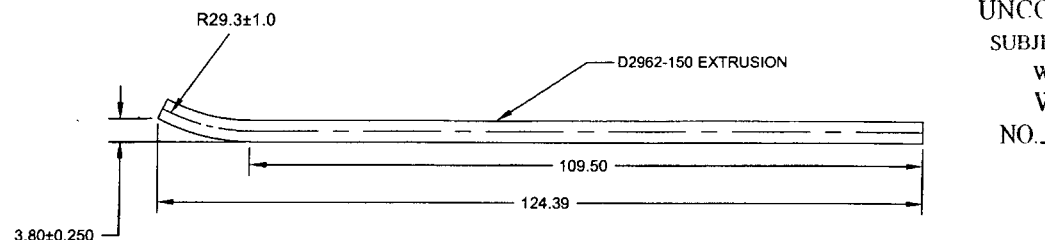
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75667
M.L.J
11/10/27

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

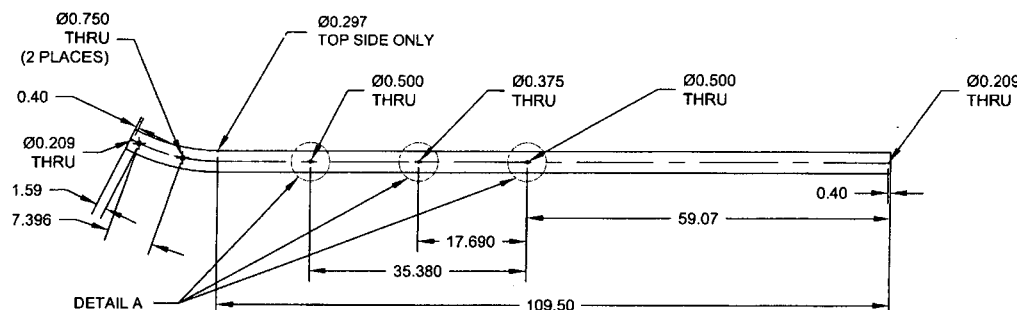
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

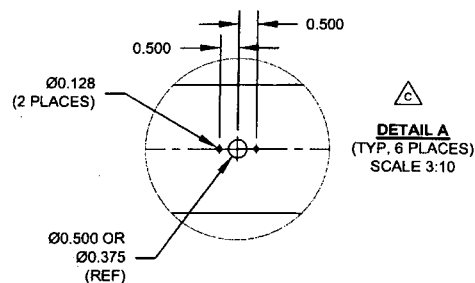
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JTC		
CHECKED	BL		
MFG. APPR.	EC		
APPROVED	DP		
DE APPR.	ST	REV. C SHEET 1 OF 2	
DATE	07.09.19	DRAWING NO. D3507	
		TITLE EC 135 SKIDTUBE	
		SCALE NTS	
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D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION C-C
(SCALE 3:10)

SECTION D-D
(SCALE 3:10)

SECTION G-G
(SCALE 3:10)

SECTION E-E
(SCALE 3:10)

DETAIL F
(SCALE 1:5)

DETAIL B
(SCALE 1:5)

D3507-041 ASSEMBLY DETAIL

DETAIL F
(SCALE 1:5)

DETAIL B
(SCALE 1:5)

RELEASED

DESIGN	14	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	024	DRAWING NO.	REV. C
MFG. APPR.	CE	D3507	SHEET 2 OF 2
APPROVED	14	TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	1:20
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 257

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B666P
Part number: D135-751-011
Description: 135
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Burns Date of Test Coupon 11-06-22

Welder Barclay Elliot Date of Test Coupon 11-06-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld